

**Amendments to the Claims:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

1. (original) In an expendable and machinable material capable of being cast in blocks machined to a desired shape, said material containing ethylene-vinyl resin and fatty acid ketone, the improvement consisting of the addition of at least one fatty acid.

2. (previously presented) An expendable and machinable pattern material capable of being cast in large blocks and machined to a casting shape useful in the lost pattern process of investment casting, said material consisting essentially of ethylene-vinyl resin, at least one fatty acid ketone and at least one fatty acid.

3. (canceled).

4. (canceled)

5. (previously presented) A pattern material consisting essentially of the following ingredients in amounts by weight based on the total weight of the material:

5-20 % ethylene-vinyl resin,

25-75 % fatty acid,

25-75 % fatty acid ketone,

0-20 % of at least one ingredient compatible with said ethylene-vinyl resin,  
fatty acid and fatty acid ketone.

6.(new)      An expendable and machinable pattern material capable of being cast and in large blocks and machined to a casting shape useful in the lost pattern process of investment casting, said material consisting essentially of ethylene-vinyl resin, at least 1 fatty acid ketone and at least one fatty acid, the ethylene-vinyl, resin, fatty acid, and fatty acid ketone being present in amounts by weight based on the total weight of the material as follows:

8-15% of ethylene-vinyl resin,

38-62% of at least one fatty acid,

38-62% of at least one fatty acid ketone.